

Split

Work Order ID 147635-2

Wednesday, June 08, 2016 2:46:26 PM

147635

Page 1

Item ID: D4436-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Bracket Assembly

3

Start Date: 6/6/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/8/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4436	A								

100

0.00

100

Small Fab

Memo

0.21

Small Fab

Assemble as per dwg and install grommet

3 FF SEP 22 2016

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.01

Quality Control

(3) DAS 38 9-89

SEP 22 2016

160

Identify as per dwg & Stock Location: 5H618

0.00

160

Packaging

Memo

0.01

Packaging

3 SEP 22 2016

DAS 6 9-89

Work Order ID 147635

Wednesday, June 08, 2016 2:46:26 PM

147635

Page 2

Item ID: D4436-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Bracket Assembly

Start Date: 6/6/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/8/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.07

DAS
21
9-89

SEP 22 2016

Quality Control

DAS
21
9-89 SEP 22 2016

Picklist Print

Wednesday, June 08, 2016 2:46:25 PM

Page 1

Work Order ID: 147635

147635

Parent Item: D4436-041

D4436-041

Parent Item Name: Aft Bracket Assembly

Start Date: 6/6/2016

Required Date: 6/8/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.10.05 NEW ISSUE DD VERF:EC
RevB 11.12.22 per PA2 EC verified by:JLM
12.01.24 PER DWG REV.A DD VERF:EC

IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4440-1		Manufactured	No			100	Each	21.0000	1	4			
D4440-1											**	FF	SEP 2 1 2016
Grommet													

Location	Loc Qty	Loc Code
GA	9	
134762	9	
ST098	12	
140598	12	

D4435-043		Manufactured	No			100	Each	3.0000	1	4			
D4435-043											**	FF	SEP 2 1 2016
Mount Bracket Assembly													

Location	Loc Qty	Loc Code
ST098	3	
143378	3	

D4436-043		Manufactured	No			100	Each	1.0000	1	4			
D4436-043											**	FF	SEP 2 1 2016
Aft Outboard Bracket Assembly													

Location	Loc Qty	Loc Code
ST621	1	
143394	1	

D4436-045		Manufactured	No			100	Each	1.0000	1	4			
D4436-045											**	FF	SEP 2 1 2016
Aft Inboard Bracket Assembly													

Location	Loc Qty	Loc Code
ST620	1	
136598	1	

NOT Pulled

B149674

② FF SEP 2 2 2016

Picklist Print

Wednesday, June 08, 2016 2:46:25 PM

Page 2

Work Order ID: 147635

147635

Parent Item: D4436-041

D4436-041

Parent Item Name: Aft Bracket Assembly

Start Date: 6/6/2016

Required Date: 6/8/2016

Start Qty: 4.00

Required Qty: 4.00

AN525-832R6

Purchased

No

100

Each

94.0000

4

16

AN525-832R6

Screw

**

FF

SEP 21 2016

Location

Loc Qty

Loc Code

CA

14

m129682

14

GA

135390

14

m131957

14

ST328

66

m134249

66

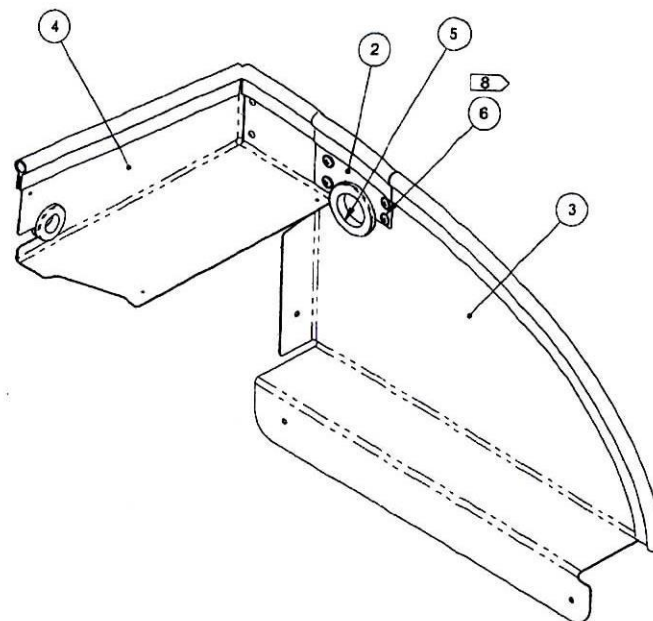
12

Wednesday, June 08, 2016 2:46:25 PM

Shop Packet Print

Page 2

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4436-041	AFT BRACKET ASSEMBLY
2	1	D4435-043	BRACKET ASSEMBLY
3	1	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
4	1	D4436-045	AFT INBOARD BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	4	AN525-832R6	SCREW



D4436-041 AFT BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.31 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

A	NEW ISSUE	RF	12.01.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4436	SHEET 1 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	COVER ASSEMBLY	NTS
DATE	12.01.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W60 147635

RELEASED
12 2012-07-23
MP